

Work Order ID 140841

January 20, 2016 11:27:17 AM

140841

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: AS350/AS355 Bearpaws

Stop ***NS2***

Start Date: 1/20/2016 Start Qty: 7.00

7

Cust Item ID:

Required Date: 2/19/2016 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan: 54

Date: 20160120

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-578	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-578-011								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCS 16-01-28

DAS
6
9-89

⑦ 16-02-13

DAS
9
9-89

⑦

7 JAN 27 2016

DAS
6
9-89

DAS
6
9-89

⑦ 16-02-13

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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Item ID: D350-578-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: AS350/AS355 Bearpaws

Stop ***NS2***Start Date: 1/20/2016 Start Qty: 7.00 ***7***

Cust Item ID:

Required Date: 2/19/2016 Req'd Qty: 7.00 ***7***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: 013

PPP 140838

7 ShB
10/2/18

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.01

Quality Control

MCS FEB 18 2016MCS FEB 18 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER :							

Picklist Print

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Work Order ID: 140841

140841

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 1/20/2016

Required Date: 2/19/2016

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2432		Manufactured	No			160	Each	1.0000	2	14			
D2432									**				
Bearpaw 19" X 24"	DAS 9 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST470A				1					
				133973				1					
D2529		Manufactured	No			160	Each	413.0000	12	84			
D2529	DAS 9 9-89								**				
Washer				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST008				313					
				137534				113					
				140017				200					
				ST009				100					
				140554				100					
D3601-1	DAS 9 9-89	Manufactured	No				Each	25.0000	10	84			
D3601-1									**				
Radius Block				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST045				25					
				139080				25					

JAN 27 2016

Picklist Print

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Work Order ID: 140841

140841

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 1/20/2016

Required Date: 2/19/2016

Start Qty: 7.00

Required Qty: 7.00

D4011-1 Manufactured No

D4011-1

DAS

Clamp, Short

9

9-89

Location

Loc Qty

Loc Code

ST544

31

140100

31

Each

128.0000

D4012-1

Manufactured No

D4012-1

DAS

Cushion

9

9-89

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

123

140153

5

140474

118

Each

224.0000

AN4-16A

Purchased No

AN4-16A

DAS

Bolt

9

9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

200

M133998

200

ST343

19

M133769

19

**

42
1/2 X 3/4 141268

DAS
6
9-89

**

30 31
42

DAS
6
9-89

**

5
37
84

DAS
6
9-89

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Picklist Print

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Work Order ID: 140841

140841

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 1/20/2016

Required Date: 2/19/2016

Start Qty: 7.00

Required Qty: 7.00

NAS1149D0463J

Purchased

No

160

Each

2,078.000

24

168

NAS1149D0463.I

WASHER

**

134039

DAS
27
9-89
DAS
6
9-89

DAS
9
9-89

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST263

331

M133932

331

ST269

1350

M130799

361

M132317

101

M132677

888

MS21042L4

DAS
9
9-89

Purchased

No

160

Each

2,254.000

12

84

MS21042I 4 9

Locknut

**

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

26

m127813

26

ST303

2090

m133769

2090

ST305

97

m130922

97

JAN 27 2016

DAS
27
9-89
DAS
6
9-89

Work Order ID 140841

January 20, 2016 11:27:17 AM

140841

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: AS350/AS355 Bearpaws

Stop ***NS2***

Start Date: 1/20/2016 Start Qty: 7.00

7

Cust Item ID:

Required Date: 2/19/2016 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan: 54

Date: 20160120

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-578	H

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

DAS
6
9-30

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-578-011 CHG006

ML5

JAN 28 2016

7

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

7 JAN 27 2016

DAS
6
9-30

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

DAS
9
9-89

16-02-13.

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
12	12	12	12	12		D2529	Washer
				2		D2672F	Bearpaw
12	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
6	6	6	6	6		D4011-1	Clamp (Replaces D2438)
6	6	6	6	6		D4012-1	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-16A	Bolt
		12	12		12	AN4-17A	Bolt
24	24	24	24	24	24	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit